



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D3368-3**Job Sheet 204819****Part No:** D3368-3**Job Qty:** 6 pcs**Part Name:** Pedal Lock Cover**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 12/20/19**Job Tracking No:****Due Date:** 2/10/20**Created By:** Jennifer Renwick**Type:** Stock**Description:****Note:** DWG REV B IPP A 05.01.27 New issue KJ/JLM IPP Rev:B 08-07-15 add QC3 DD verified by:ec**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	2/10/20	2/10/20	0.00	6.84	Bandsaw - 1		LA 20/03/06
105	HAAS 4 Axis - B4B	6 pcs	2/10/20	2/10/20	1.00	6.84	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	QC 2	6 pcs	2/10/20	2/10/20	0.00	0.00	QC 2 - 1		QC 2-03-09
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

**Container No:** S261642**Part:** D3368-3**Job No:** 204819**Serial No/Batch:** S261642**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 03/08/20

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					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
120 QC 8	6 pcs	2/10/20	0.00	0.00	QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	Le 20-04-28
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130 Handfinish - 1-1 Chemical-B4B	6 pcs	2/10/20	0.00	0.75	Handfinish - 1 - 1 - B4B	BEB 20-05-12
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 -	

					B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
132	QC 7	6 pcs	2/10/20	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	20-05-13
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	20-05-15
					Powdercoat - 4 - B4B	
140	Powdercoat - 6 Fire Red - B4B	6 pcs	2/10/20	0.00 0.48	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
150	QC 3	6 pcs	2/10/20	0.00 0.00		

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				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
160	Packaging 3-1 - Stock - B4B	6 pcs	2/10/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
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					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
170	QC 21 - SA	6 pcs	2/10/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Bandsaw) cut at 10.450" Descriptions: 105 - (HAAS CNC Vertical Machine) Machine D3368-3 as per Folio FA500 and Dwg D3368 Identify as D3368-3 Deburr 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Chemical Conversion Coat per QSI005 4.1 132 - QC7-Inspect Chemical Conversion Coat 140 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3) Heat oven at temperature for 45 minutes before putting part in oven by: _____ Start Time: _____ Oven Temperature: _____ Finish Time: _____ 150 - QC3- Inspect Part Finish 160 - Identify as per dwg & Stock Location: _____ 170 - QC21- Final Inspection - Work Order Release					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X02.000	6061-T6 Bar 2.00 X 2.00	5.2260 ft (.871 ea)	100-Bandsaw - 1	5225342
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.000X02.000	5	10	0
Part Specifications				
Specifications could not be found.				

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KT AEROSPACE LTD		Work Order:	204819
Description: Pedal Lock Cover		Part Number:	D3368-3
Inspection Dwg: D3368 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.246	✓		3/006	H-G
7.250	+/-0.010	7.253	✓		3/006	H-G
0.650	+/-0.010	0.650	✓		Kt-05	Vern
0.107	+/-0.010	0.102	✓		3/006	H-G
1.800	+/-0.010	1.801	✓		Kt-05	Vern
45°	+/-0.5°	45°	✓		mic-17	A-G
Ø1.300	+/-0.010	1.305	✓		Kt-05	Vern
Ø1.400	+/-0.010	1.395	✓		" "	" "
Ø1.031	+/-0.010	1.030	✓		" "	" "
0.250	+/-0.010	0.255	✓		" "	" "
1.500	+/-0.010	1.500	✓		3/006	H-G
1.440	+/-0.010	1.445	✓		Kt-05	Vern
2.00	+/-0.030	1.995	✓		" "	" "
7°	+/-0.5°	7°	✓		mic-17	A-G
0.635	+0.010/-0.000	0.638	✓		Kt-05	Vern
Ø1.250	+/-0.005	1.255	✓		" "	" "
0.250 deep	+/-0.010	0.246	✓		" "	" "
1.000	+/-0.010	1.000	✓		Kt-05	Vern
1.450	+/-0.010	1.450	✓		" "	" "
0.375	+/-0.010	0.375	✓		Kt-05	Vern
0.310	+/-0.010	0.310	✓		Kt-05	Vern
Ø0.750	+0.010/-0.000	0.752	✓		" "	" "
Ø0.185	+0.005/-0.000	0.188	✓		Kt-05	Vern

Measured by:	Kt 9-89
Date:	20-03-09

Audited by:	Be
Date:	20-04-28

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	
C	08.07.23	Ø0.201 & Ø0.136 dimensions removed	KJ/DD	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																															
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)																															
Description Work Order Deviation		Disposition																																	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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		Other/Details:																																	
		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																																	